

Work Order ID 117229

117229

Page 1

July-10-14 10:27:20 AM

Item ID: D2010-101 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mirror Bracket 369/500
 Start Date: 4/23/14 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/23/14 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-01-29 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2010	Rev D

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2010-101 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
4/7/18

(12) mm 14/07/17

(12) mm 14/07/17

12

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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	NC BRAKE	0.00							14/07/21
140									
Brake NC	Memo	0.02			DAS	12			
Brake NC	Form as per Dwg D2010				30				
					9-89				
145	Chemical Conversion Coat per QSI005 4.1	0.00							
145									
HandFinish	Memo	0.00				12		14/07/24	
Hand Finishing									
147	QC7-Inspect Chemical Conversion Coat	0.00							
147									
QC	Memo	0.00				12x		14/07/24	
Quality Control									

DAS
36i
9-89

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Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

12

12

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

DAS
36
9-8J

0.00

Small Fab

0.00

Small Fab

Memo

Small Fab

Install fasteners per Dwg D2010

0.00

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

0.00

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Powdercoat

Memo

Powder Coating

*****INSTALL BOLT IN INSERT PRIOR TO POWDER COAT*****

START TIME 8:15

OVENTEMPERATURE: 320

FINISH TIME 8:45

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Item ID: D2010-101 Accept *N900040100* Setup Start *NS1*
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 Required Date: 4/23/14 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12			
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>374/80</u> Memo	0.00 0.00				12X	DAS 28 9.89	JUL 28 2014	
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							14/7/28 JF JMF 14-7-28

Picklist Print

July-10-14 10:27:23 AM

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Work Order ID: 117229

117229

Parent Item: D2010-101

D2010-101

Parent Item Name: Mirror Bracket 369/500

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: E02.06.25Added Rev. C1 KJ/RF

IPP Rev:F 07-08-015 Now on WaterJet Verified By:EC

IPP Rev:G 08-05-27 as per ECN1195P DD verified by:EC

IPP Rev:H 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

150

sf

135.6339

0.3472

5

M2024T3S 063

2024-T3 .063 sheet

**

mm 14/07/17

Location

Loc Qty

Loc Code

MAT022

135.6339

123701

16.1039

m127866

31.93

m128354

87.6

4.6

FE-032-EF

Purchased

No

100

Each

97.0000

4

48

FF-032-EF

Inserts

**

14/07/24 DAS 36 9-89

Location

Loc Qty

Loc Code

ST

97

m127922

97

48

DART AEROSPACE LTD		Work Order: 117229
Description: Bracket		Part Number: D2010-101
Inspection Dwg: D2010	Rev: D	Page 1 of 1

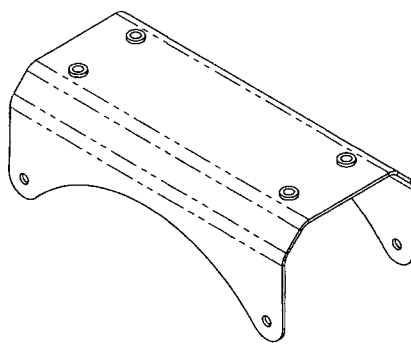
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.56	+/-0.030	6.56	✓		T-Jkm-06	
5.81	+/-0.030	5.81	✓		U-Jkm-01	
0.38	+/-0.030	0.38	✓			
0.75	+/-0.030	0.75	✓			
0.38	+/-0.030	0.38	✓			
1.375	+/-0.010	1.375	✓			
Ø0.290	+0.005 -0.000	0.290	✓			
7.05	+/-0.030	7.05	✓			
Ø0.201	+0.005 -0.000	0.201	✓			
6.30	+/-0.030	6.30	✓			

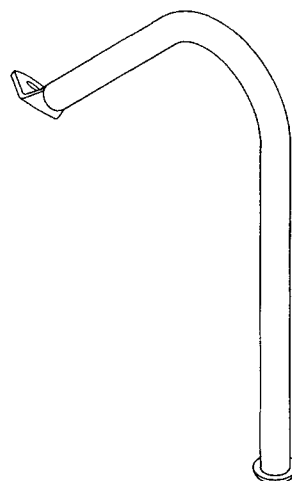
Measured by: mm	Audited by: DAS 27	Preliminary Approval:
Date: 14/07/17	Date: 14/7/18	Date:

Rev	Date	Change	Revised by	Approved
A	03.10.06	New Issue	KJ/RF	
B	06.03.08	Dwg rev. changed	KJ/JLM	
C	08.07.22	Dimension 5.06 removed	KJ/DD	
D	11.03.17	Dimension 7.05 revised	KJ	

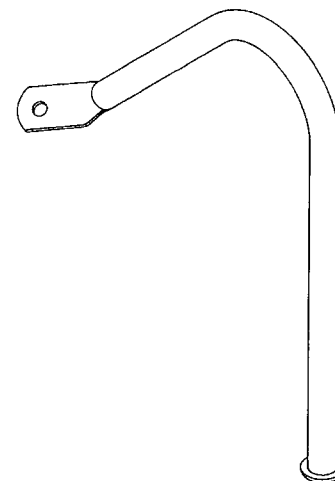
8 7 6 5 4 3 2 1



D2010-101 MIRROR BRACKET



D2010-103 ARM



D2010-104 ARM

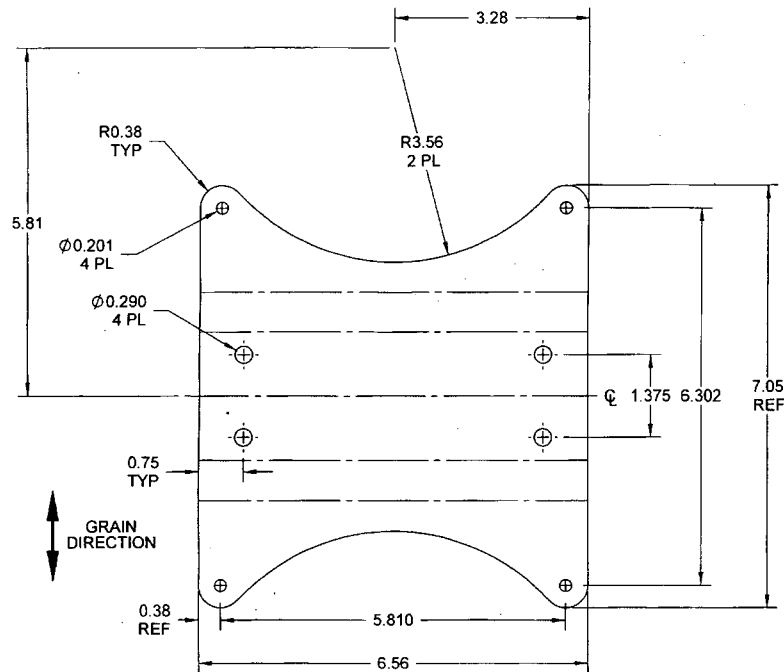
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 117 229 MWS
1404-29

RELEASED
08.06.10

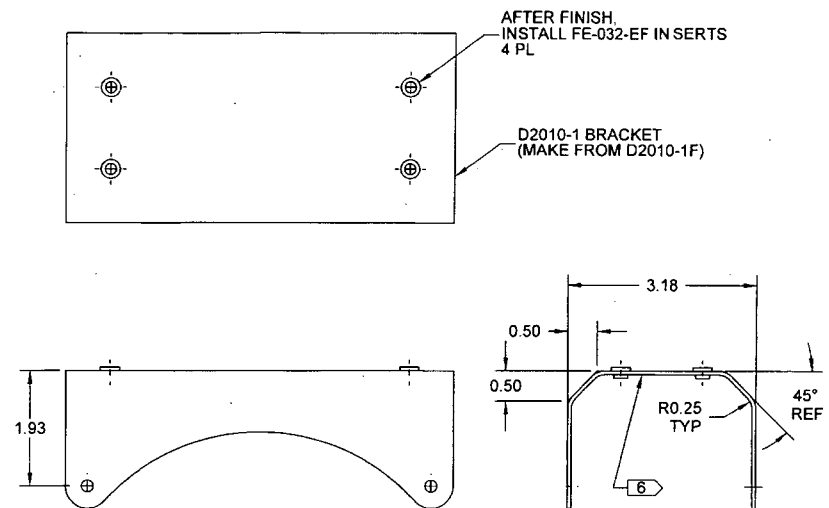
D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2010 REV. D SHEET 1 OF 4 TITLE MIRROR BRACKET SCALE NTS COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB		
DATE	08.06.10		

8 7 6 5 4 3 2 1

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



D2010-1F FLAT PATTERN



D2010-101 MIRROR BRACKET

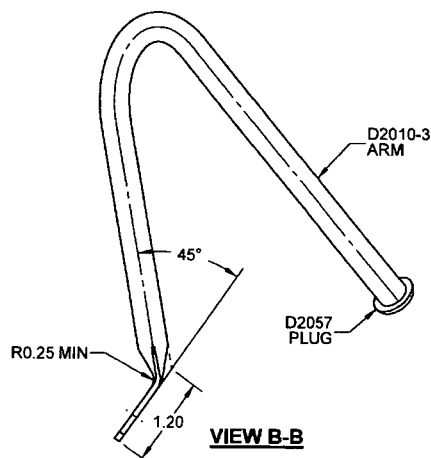
RELEASED
08-06-19/11

- NOTES:**
- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
 - 7) WEIGHT: 0.23 lbs

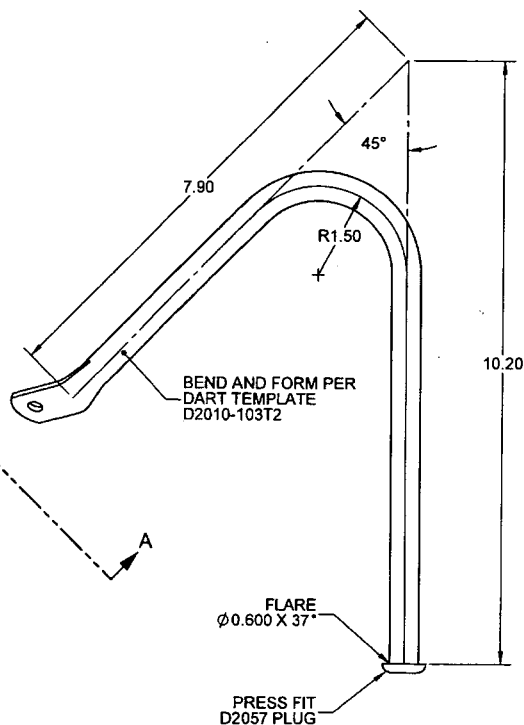
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DE APPR.	JB	NTS	
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8 7 6 5 4 3 2 1

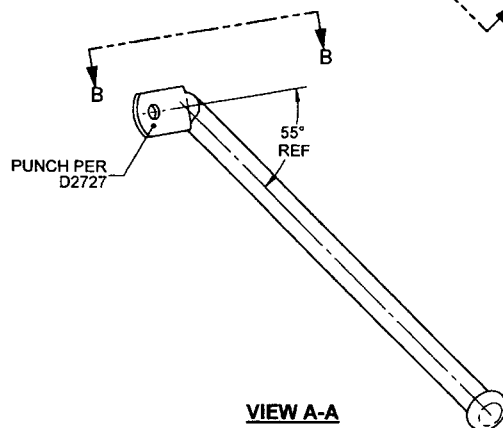
QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



VIEW B-B



D2010-103 ARM



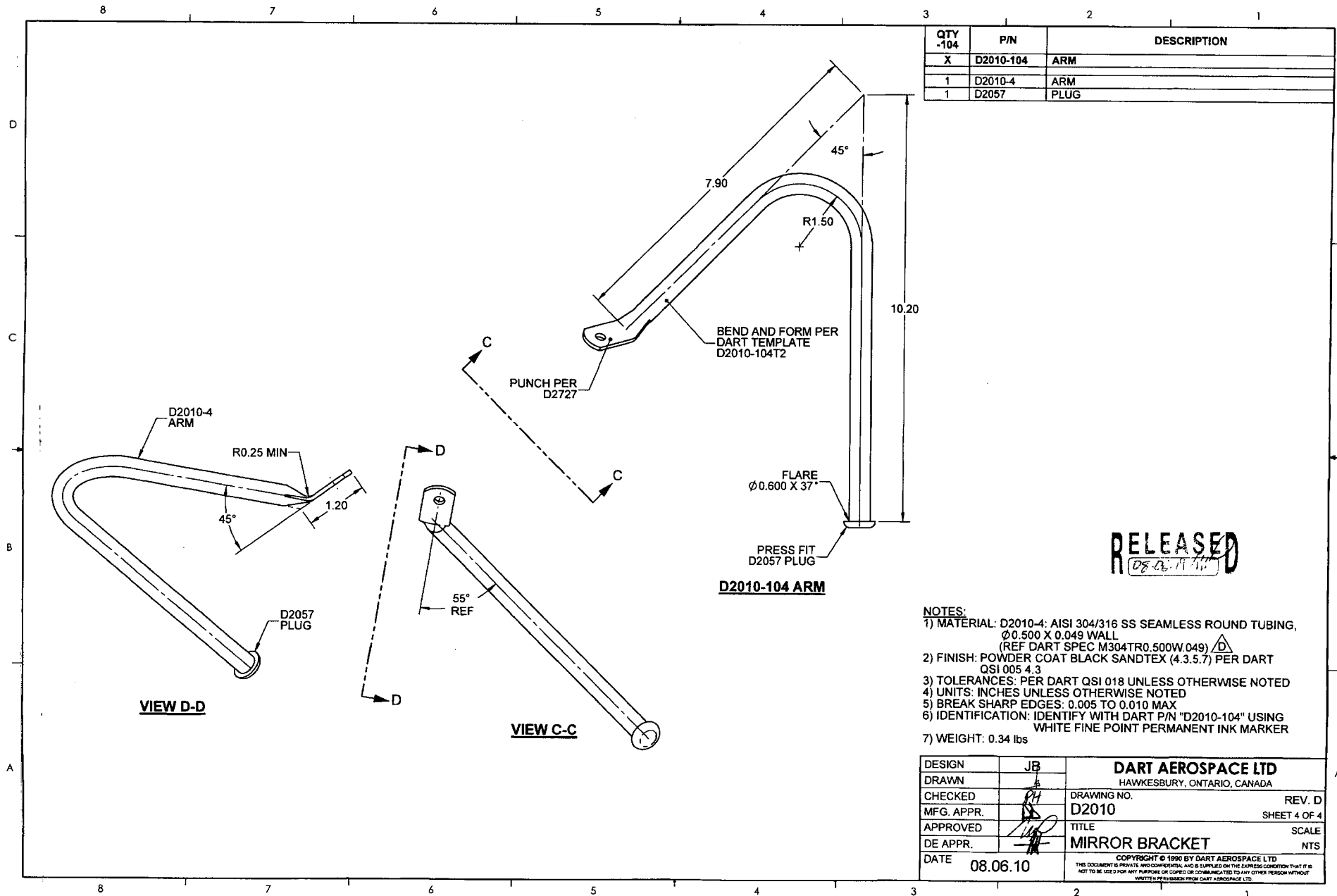
VIEW A-A

RELEASED
08.06.10

- NOTES:**
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD
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MFG. APPR.	PH	SHEET 3 OF 4
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DE APPR.	PH	
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8 7 6 5 4 3 2 1



QTY	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG

RELEASED

- NOTES:**
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø 0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W 049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

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